

Amendments to the Claims:

This listing of claims will replace all prior versions and listings of claims in the application:

Listing of Claims:

Claims 1-85 (canceled)

1 Claim 86 (new): A method for manufacturing a product having
2 a coating which comprises manufacturing a base product from
3 at least one mass comprising at least natural polymers,
4 applying a first coating to at least a portion of the base
5 product, and applying a second coating which is different
6 from the first coating over at least a portion of the first
7 coating such that at least a part of the base product is
8 covered by overlapping first and second coatings and a
9 further part of the base product is covered by the first or
10 second coating alone, the surface tension of at least the
11 first coating being approximately equal to or lower than the
12 surface tension of at least the or each part of the base
13 product to which the first coating is applied.

1 Claim 87 (new): A method in accordance with claim 86 wherein
2 the surface tension of at least the first coating is lower
3 than the surface tension of at least the or each part of the
4 base product to which it is applied.

1 Claim 88 (new): A method in accordance with claim 86 wherein
2 the base product is formed under increased pressure and/or
3 temperature in a mold.

1 Claim 89 (new): A method in accordance with claim 88 wherein
2 the at least one mass further comprises a surface tension
3 reducing agent and is introduced in or through the mold, and
4 wherein the at least one mass is heated in the mold such
5 that cross-linking of the natural polymers occurs.

1 Claim 90 (new): A method in accordance with claim 88 wherein
2 the at least one mass further comprises a release agent in
3 an amount such that when the temperature of the mass is
4 increased a portion of the release agent egresses from the
5 mass and bonds to the molding surface of the mold, and
6 wherein during the manufacture of successive products in the
7 same mold, a substantially constant layer of the release
8 agent always remains bonded to the molding surface.

1 Claim 91 (new): A method in accordance with claim 90 wherein
2 the release agent is also a surface tension reducing agent.

1 Claim 92 (new): A method in accordance with claim 91 wherein
2 the base product is formed by means of injection molding.

1 Claim 93 (new): A method in accordance with claim 91 wherein
2 at least one mass is substantially manufactured as
3 paper-forming mass.

1 Claim 94 (new): A method in accordance with claim 91 wherein
2 at least one of the coatings has a surface tension of less
3 than 42 dyne/cm ($42 \times 10^{-3} \text{N/m}$).

1 Claim 95 (new): A method in accordance with claim 94 wherein
2 at least one of the coatings has a surface tension of less
3 than 36 dyne/cm ($36 \times 10^{-3} \text{N/m}$).

1 Claim 96 (new): A method in accordance with claim 95 wherein
2 at least one of the coatings has a surface tension of less
3 than 32 dyne/cm (32×10^{-3} N/m).

1 Claim 97 (new): A method in accordance with claim 88 wherein
2 the base product, after leaving the mold in which it was
3 formed, has a surface tension of less than 44 dyne/cm
4 (44×10^{-3} N/m) and greater than 30 dyne/cm (30×10^{-3} N/m) and
5 wherein at least the first coating applied to at least a
6 portion of said surface is water based and has a surface
7 tension of between 40 dyne/cm (40×10^{-3} N/m) and 27 dyne/cm
8 (27×10^{-3} N/m).

1 Claim 98 (new): A method in accordance with claim 97 wherein
2 the base product upon leaving the mold has a moisture
3 content of less than 3 wt% and wherein by means of one of
4 the coatings moisture is introduced into the coated product.

1 Claim 99 (new): A method in accordance with claim 98 wherein
2 at least one of the coatings is a water-based one-phase
3 system.

1 Claim 100 (new): A method in accordance with claim 99
2 wherein the water-based one-phase system has few micelles.

1 Claim 101 (new): A method in accordance with claim 86
2 wherein at least the first coating is applied to the base
3 product, the base product having a temperature of between
4 20°C and 50°C and the coating having a lower surface tension
5 at the application temperature compared with the surface
6 tension of at least the portion of the base product to which
7 the coating is applied.

1 Claim 102 (new): A method in accordance with claim 101
2 wherein at least the first coating is applied at a
3 temperature of between 25°C and 50°C.

1 Claim 103 (new): A method in accordance with claim 86
2 wherein the first coating comprises at least one component
3 selected from the group consisting of melamine, acrylic
4 binders, water-resistant lacquers, cellulose lacquers,
5 cellulose acetate propionates, polyethylene, polyacrylates,
6 synthetic polymers, natural polymers, synthetic waxes,
7 natural waxes, polyactic acid and derivatives thereof.

1 Claim 104 (new): A method in accordance with claim 103
2 wherein the first coating comprises one or more waxes
3 combined with at least one other component.

1 Claim 105 (new): A method in accordance with claim 103
2 wherein the second coating comprises at least one component
3 selected from the group consisting of acrylic binders,
4 latices, styrene-butadiene latex, polyvinyl alcohol,
5 polyvinyl acetate, polyacrylates, polyethylene glycol,
6 polyactic acid, synthetic polymers, natural polymers,
7 natural waxes, synthetic waxes and derivatives thereof.

1 Claim 106 (new): A method in accordance with claim 105
2 wherein the second coating comprises synthetic waxes in the
3 form of ionic polyethylene waxes.

1 Claim 107 (new): A method in accordance with claim 105
2 wherein cross-linking compounds are incorporated in at least
3 one of the coatings.

1 Claim 108 (new): A method in accordance with claim 107
2 wherein the crosslinking compounds are selected from the
3 group consisting of zirconium acetate, urea formaldehyde,
4 melamine, formaldehyde, glyoxal, ammonium zirconium
5 carbonate, polyamideamine-epichlorohydrin, epoxides,
6 trimetaphosphate, and derivatives thereof.

1 Claim 109 (new): A method in accordance with claim 105
2 wherein at least one of the coatings increases the water
3 vapor resistance of the product.

1 Claim 110 (new): A method in accordance with claim 109
2 wherein as an outer coating the first and/or second coating
3 is fat resistant.

1 Claim 111 (new): A method in accordance with claim 105
2 wherein at least one of the coatings is applied to only one
3 part of the product and the surface tension of the parts of
4 the product that remain clear of that coating are kept or
5 rendered relatively low with respect to the surface tension
6 of said coating.

1 Claim 112 (new): A method in accordance with claim 105
2 wherein the base product is manufactured from at least two
3 different masses.

1 Claim 113 (new): A method in accordance with claim 112
2 wherein the two different masses form parts of the base
3 product which have different surface tensions.

1 Claim 114 (new): A method in accordance with claim 113
2 wherein at least one of the coatings is applied to the base
3 product by spraying.

1 Claim 115 (new): A method in accordance with claim 113
2 wherein at least one of the coatings is applied to the base
3 product by atomizing.

1 Claim 116 (new): A method in accordance with claim 113
2 wherein at least one of the coatings is applied by airless
3 spraying.

1 Claim 117 (new): A method in accordance with claim 113
2 wherein at least one of the coatings is applied by
3 compressed air spraying.

1 Claim 118 (new): A method in accordance with claim 86
2 wherein the base product has at least one receiving cavity
3 which is at least partially filled with fluid of either the
4 first or second coating and subsequently poured empty
5 whereby a film of the first or second coating remains behind
6 on at least a portion of the wall of the receiving cavity.

1 Claim 119 (new): A method in accordance with claim 118
2 wherein on or in at least a part of the base product there
3 is provided prior to the application of the first coating to
4 said part an agent capable of influencing the properties of
5 said product part.

1 Claim 120 (new): A method in accordance with claim 119
2 wherein the agent is a softener.

1 Claim 121 (new): A method in accordance with claim 119
2 wherein the agent is water or a water containing agent.

1 Claim 122 (new): A method in accordance with claim 119
2 wherein the second coating comprises the agent and the first
3 coating is substantially impermeable to said agent.

1 Claim 123 (new): A method in accordance with claim 119
2 wherein at least one of the coatings comprises a surface
3 tension reducing which provides for a reduction of the
4 surface tension of that coating after it has dried.

1 Claim 124 (new): A method in accordance with claim 123
2 wherein the surface tension reducing agent is an oil or oil
3 containing product.

1 Claim 125 (new): A method in accordance with claim 123
2 wherein the surface tension reducing agent is a silicone
3 oil.

1 Claim 126 (new): A method in accordance with claim 125
2 wherein the at least one coating comprises between 0.5 and
3 15 volume % of a silicone oil.

1 Claim 127 (new): A method in accordance with claim 125
2 wherein the at least one coating comprises between 2 and 10
3 volume % of a silicone oil.

1 Claim 128 (new): A product in accordance with claim 127
2 wherein a portion of the product is provided with a moisture
3 permeable or vapor permeable coating.

1 Claim 129 (new): A product in accordance with claim 128
2 wherein said portion is a portion of the product which faces
3 outward during use.

1 Claim 130 (new): A product in accordance with claim 129
2 wherein the product is a cup comprising a bottom, a
3 longitudinal edge of the longitudinal wall, at least a
4 portion of the outer side of the longitudinal wall being
5 provided with a substantially water proof coating and at
6 least a further part of the outer side of the longitudinal
7 wall being uncoated or provided with said moisture permeable
8 or vapor permeable coating.

1 Claim 131 (new): A product in accordance with claim 130
2 wherein at least a portion of the outer side of the
3 longitudinal wall is a portion which extends to the free
4 longitudinal edge thereof.

1 Claim 132 (new): A product in accordance with claim 131
2 wherein at least the bottom of the cup is provided with two
3 layers of coating.

1 Claim 133 (new): A method in accordance with claim 86
2 further comprising a release agent which is incorporated in
3 the at least one mass and wherein the release agent alters
4 the surface tension of at least a portion of the base
5 product compared with that of a base product in the absence
6 of the release agent.

1 Claim 134 (new): A method in accordance with claim 133
2 wherein the base product is formed in a mold and wherein by
3 means of the release agent egressing from the at least one

4 mass a substantially constant layer of the release agent is
5 obtained and maintained on the molding surface of the mold
6 during the manufacture of successive parts.

1 Claim 135 (new): A mass comprising natural polymers for the
2 manufacturing of a base product wherein the base product is
3 suitable for applying a coating thereto, and wherein the
4 mass comprises from 0.075 weight% and 1.5 weight% of a
5 surface tension reducing agent in the form of an oil or oil
6 based agent calculated relative to the mass in a dry state.

1 Claim 136 (new): A mass in accordance with claim 135
2 comprising from 0.1 weight% and 1 weight% of the surface
3 tension reducing agent.